

Date: Wednesday, 7/11/2007 3:05:50 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP SPACER		
Job Number	33510A			Part Number	D30651		
Estimate Number	10375			Drawing Number	D3065 REV. B		
P.O. Number	N/A			Project Number	N/A		
This Issue	7/11/2007 S.O. No. : N/A			Drawing Revision	B		
Prsh Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	7/30/2007		
Previous Run	32032A			Qty:	250	Um:	Each
Written By							
Checked & Approved By	<i>PF 07.07.11</i>						
Comment	Est:C	02.11.01	Incorporated D3066-1 IPP	KJ/RF			
	Est:D	06.04.25	Water jet	EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING ISSUE P.O TO GFI <u>4149</u> <u>C207/07/12</u> (250) CUT AND FORM PER DRWG D3065 REV.B		
2.0	D30651	Step Spacer
Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s) Step Spacer		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 RECEIVE AND INSPECT FOR TRANSIT DAMAGE ENSURE MATERIAL CERTIFICATION IS ATTACHED <u>250</u> <u>07/08/16</u> (260) <u>Counted</u>		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>QSP019</u> <u>EP</u> <u>07/08/16</u> (X750)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>John</u> <u>07/09/28</u> (250)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 33510A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML 07/09/07

250

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

QSP019

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/09/24

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/09/24

Job Completion



U 07-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33510 A
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

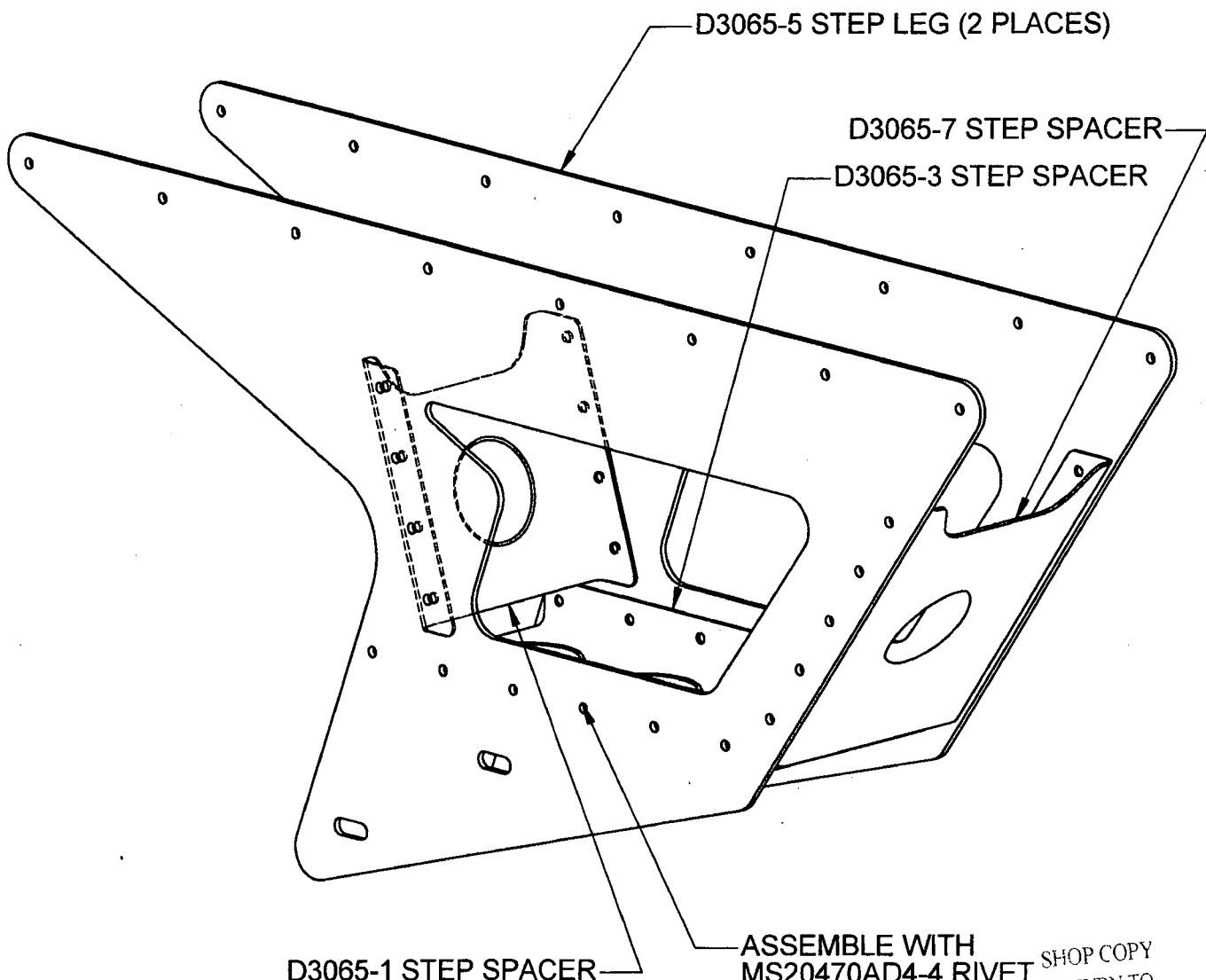
Measured by:	Audited by:	Prototype Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 1 OF 5
		TITLE STEP LEG ASSEMBLY

A	02.09.11	NEW ISSUE
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

RELEASED*06.06.20 [Signature]*

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *33510A*

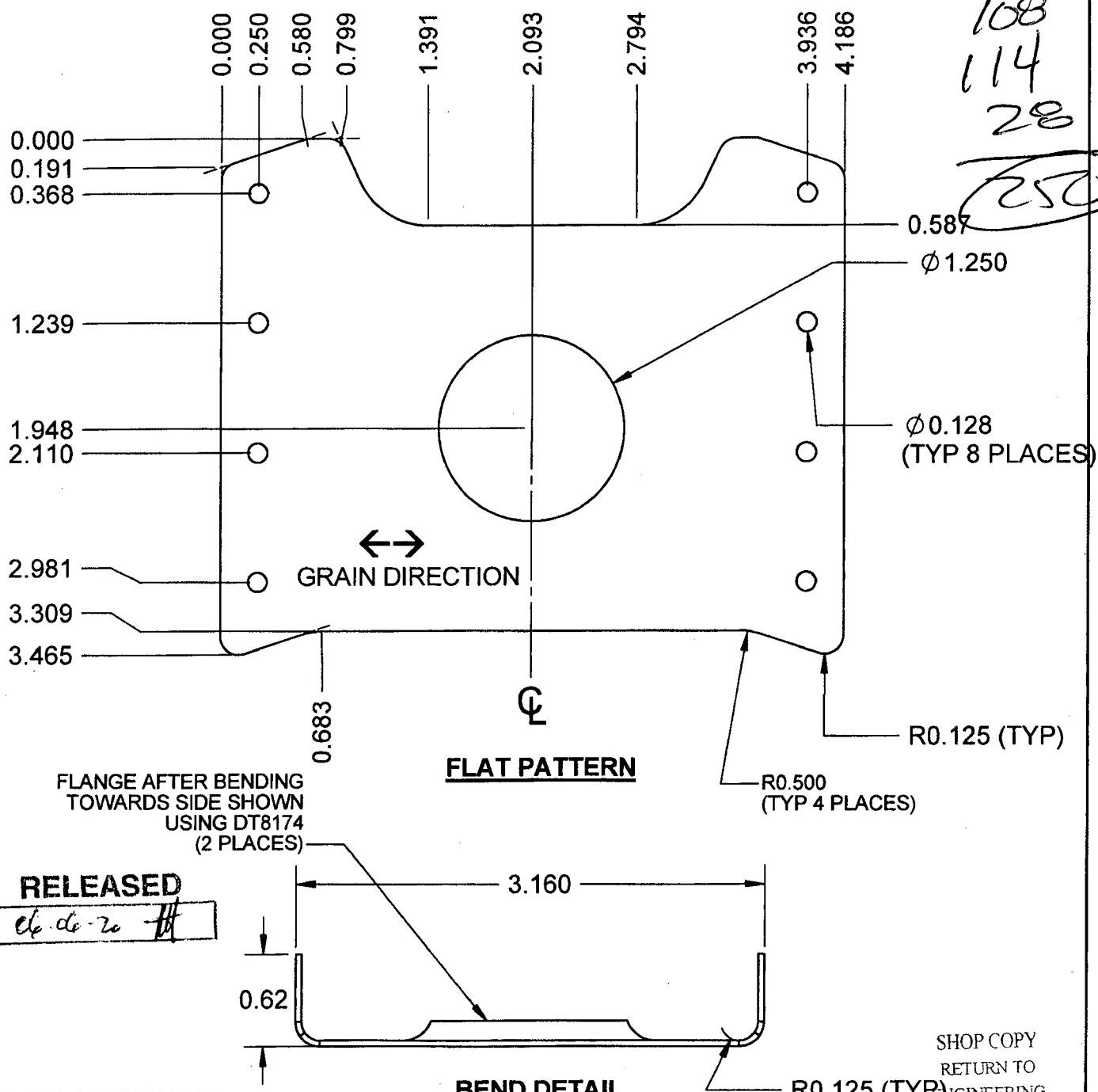
D3065-041 STEP LEG ASSEMBLY

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DART

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

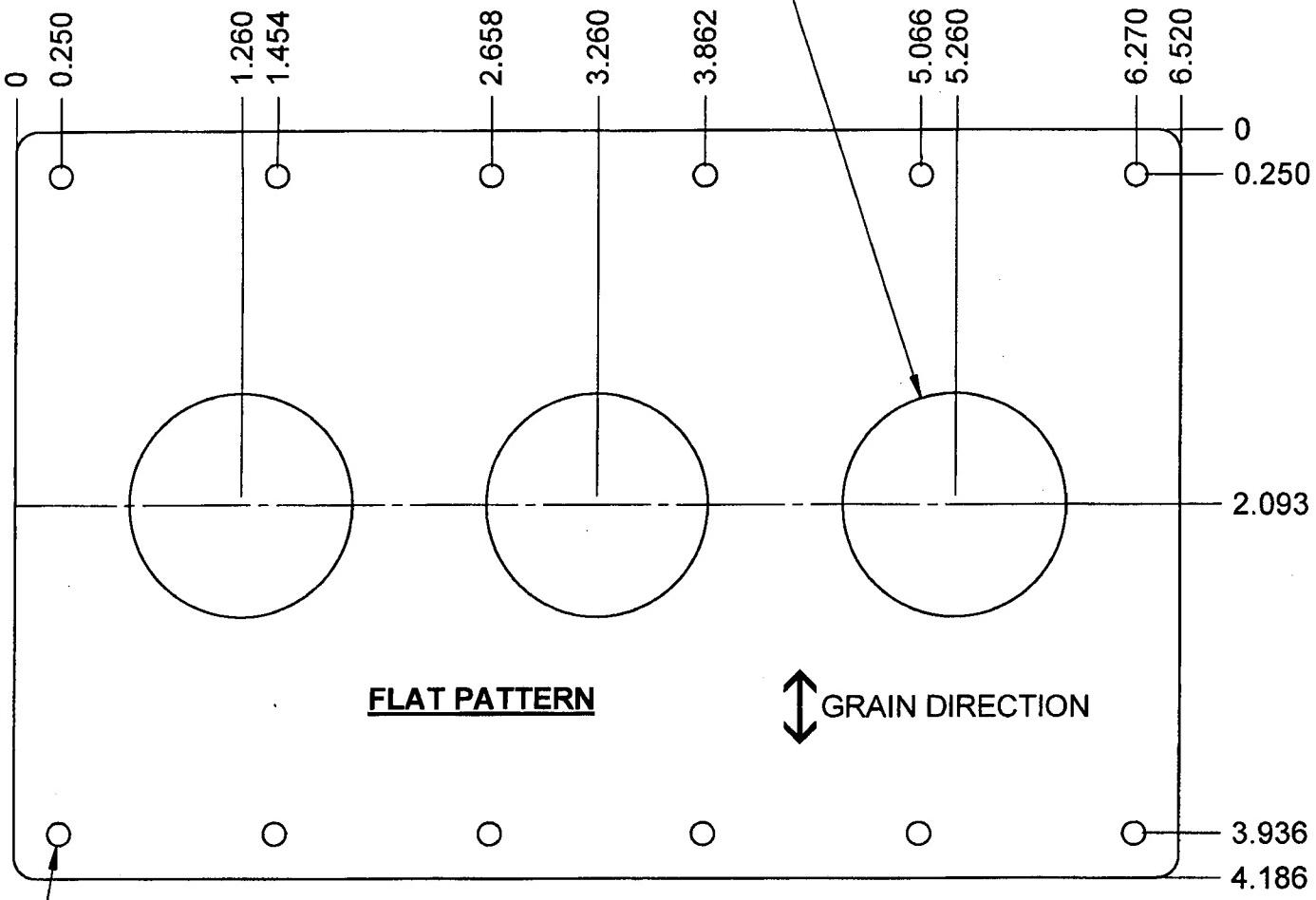
**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

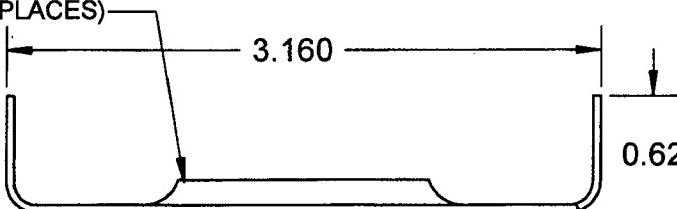
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WITHOUT NOTICE
WORK ORDER
NO. 33510A

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

 $\phi 1.250$ (TYP, 3 PLACES)**FLAT PATTERN**

↔ GRAIN DIRECTION

 $\phi 0.129$ (TYP, 12 PLACES)**RELEASED***06 Oct 20 - MM***BEND DETAIL****D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

R0.125
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WORK ORDER
NO. *33510A*

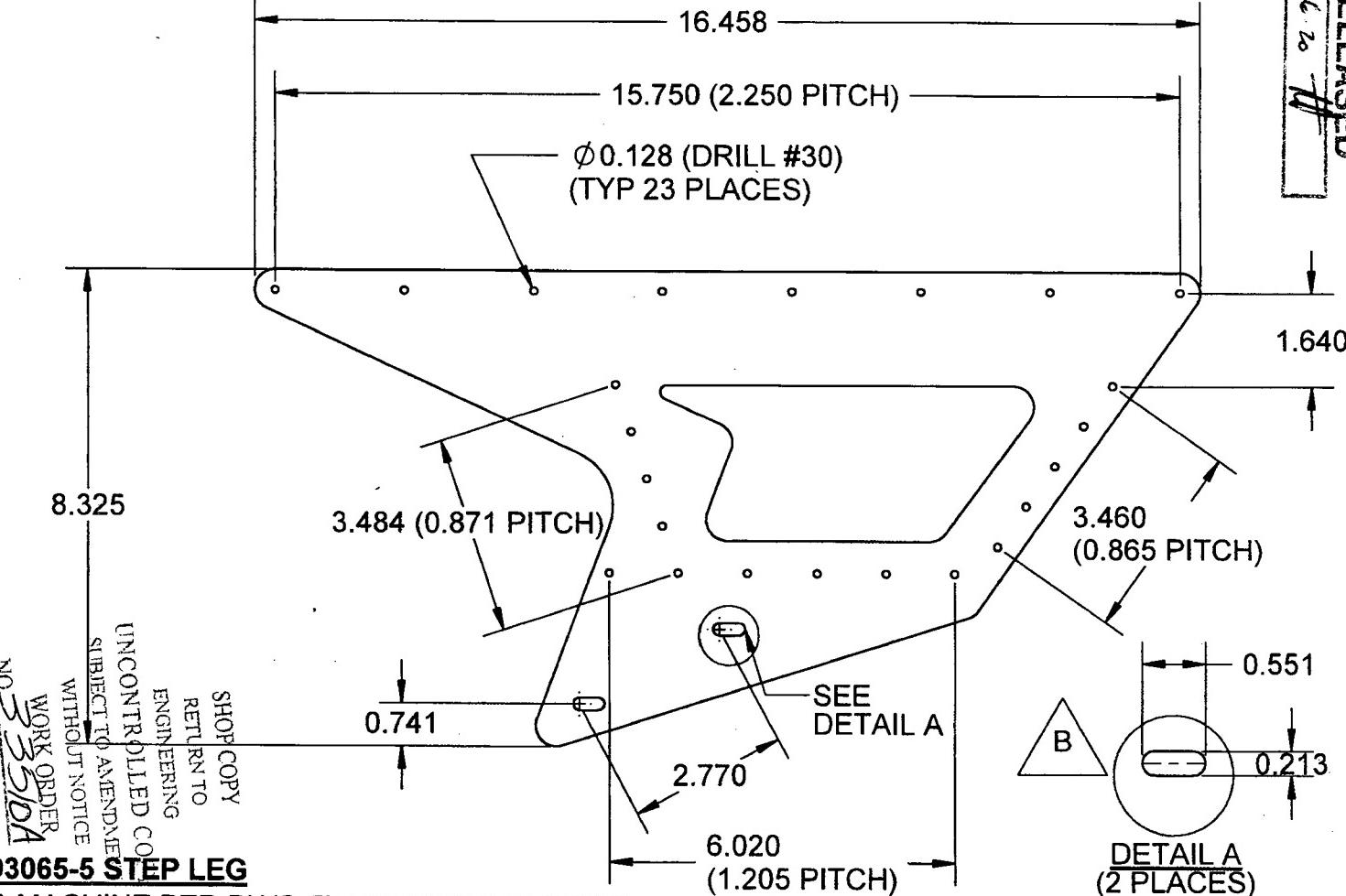
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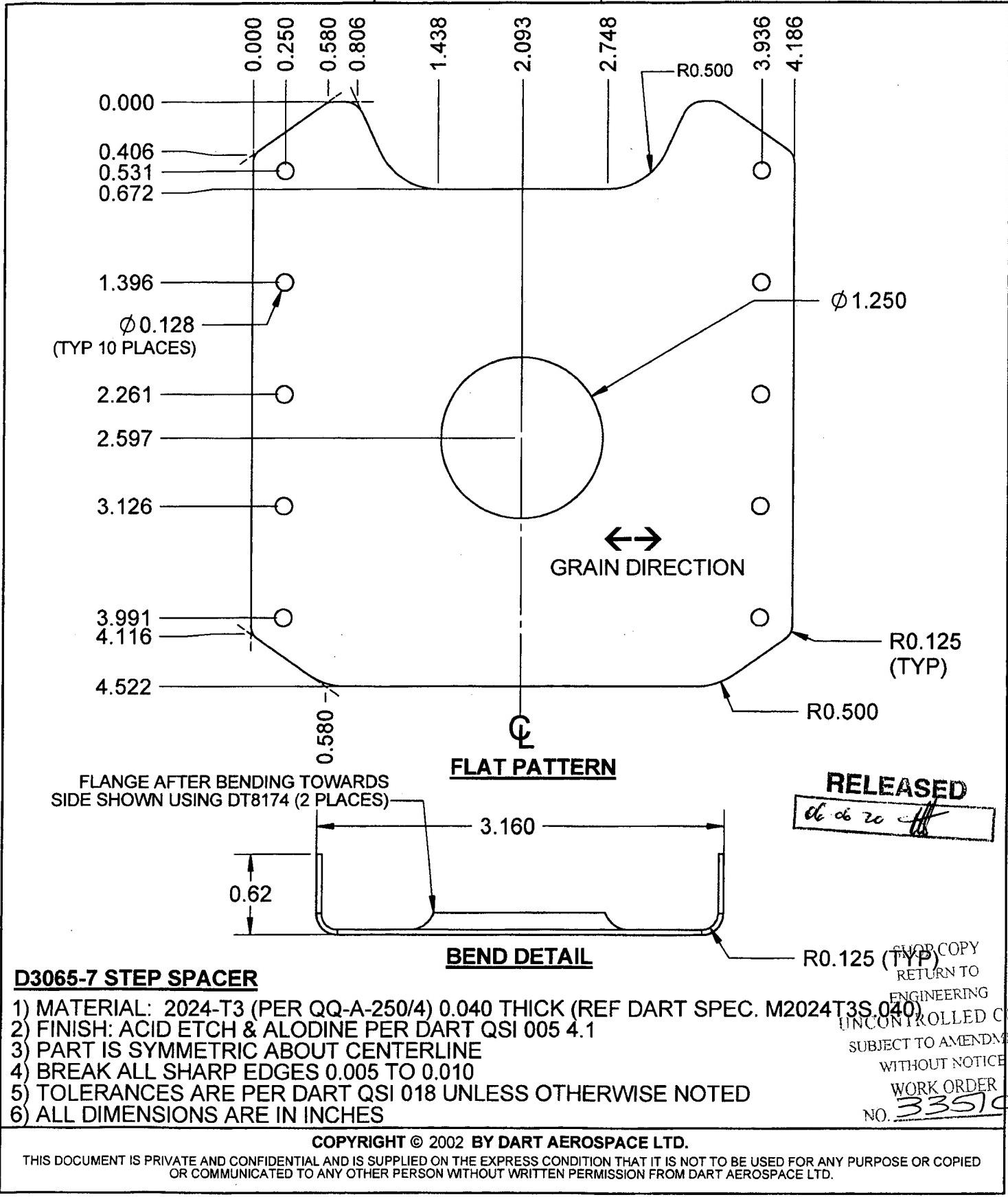
DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>JM</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 13

RELEASED
06.06.20 *H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>CP</i>	DRAWN-BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1





Non Address:	DART AEROSPACE 1270 Aberdeen St. Hawkesbury ON K6A 1K7	Date:	2007-06-19
		Reference:	D3065
Attention: Tel:	LINDA LACELLE (613)632-9577	GFI Quote:	B 6646-rev A
		Fax:	(613) 632-1053

In reply to your request for quotation, we take pleasure in quoting the following parts:

GENERAL NOTES:

- Delivery 4 weeks
 - Quote is valid 30 days.
 - Payment terms: Net 30 days
 - Freight: FOB our plant.
 - Federal and Provincial taxes are not included. This quotation is based on documents in our possession. Any changes or omissions can modify our price.
 - Prices quoted are subject to change due to present market prices stated in the quotation.

Federal and Provincial taxes are not included. This quotation is based on documents in our possession. Any changes or omissions can modify our price.

Due to the fluctuating costs of raw materials in the present market, prices stated in the quotation above are subject to change. Purchase orders may be subject to price revisions before acceptance.

PEDRO MENDEZ 2007-06-18



Non DART AEROSPACE Date: 2007-06-15
 Address: 1270 Aberdeen St.
 Hawkesbury ON K6A 1K7 Reference: D3065
 Attention: LINDA LACELLE GFI Quote: B 6646
 Tel: (613)632-9577 Fax: (613) 632-1053

In reply to your request for quotation, we take pleasure in quoting the following parts:

Part/Drawing Number	Description	Quantity	Price Each
D3065-1	LEG ASSY	250	5.00\$
		500	4.78\$
D3065-3	LEG ASSY	250	6.36\$
		500	6.14\$
D3065-5	LEG ASSY	250	10.09\$
		500	9.30\$
D3065-7	LEG ASSY	250	5.71\$
		500	5.19\$
	MATERIEL, PUNCH and BEND INCLUDED		
	LIGHTENING HOLE and FINISHING ARE NOT INCLUDED		

GENERAL NOTES:

- Delivery 4 weeks
- Quote is valid 30 days.
- Payment terms: Net 30 days
- Freight: FOB our plant
- Federal and Provincial taxes are not included. This quotation is based on documents in our possession. Any changes or omissions can modify our price.

Due to the fluctuating costs of raw materials in the present market, prices stated in the quotation above are subject to change. Purchase orders may be subject to price revisions before acceptance.

PEDRO MENDEZ 2007-0615

514 630 4847

L Lacelle

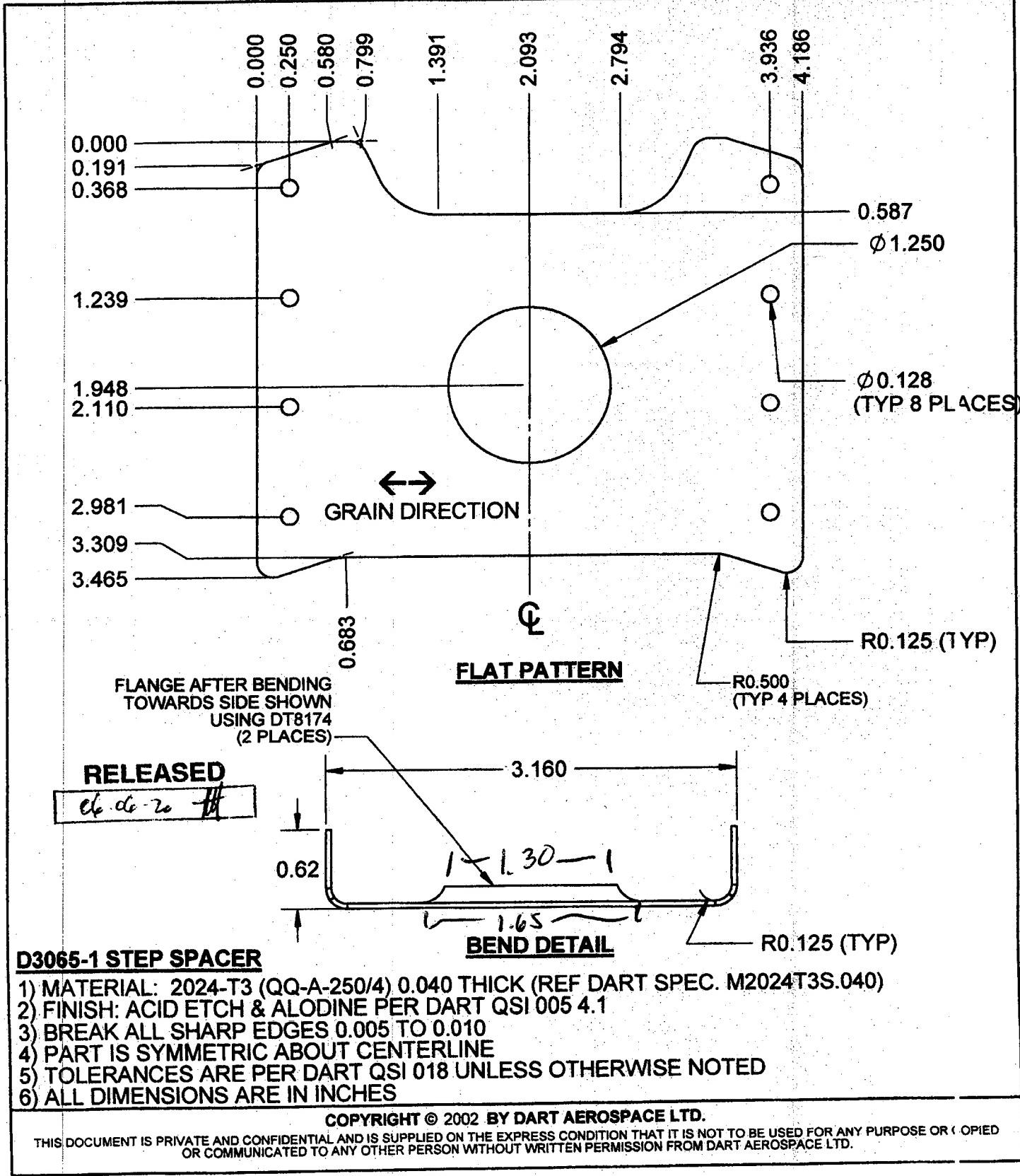
From: L Lacelle [llacelle@dartaero.com]
Sent: June 18, 2007 9:06 AM
To: Pedro Mendez (Pedro Mendez)
Subject: D3065 your quote B 6646
Importance: High

Hi Pedro,
What would be the price adder if you were to flange the holes on drwgs D3065-1/-3/-7 ? The size of the flanged hole is .1.30, we could send you our tooling.
We are very interested in giving you this order.

Thx
Linda

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	F.E.V. B
PH	<i>[Signature]</i>	D3065	SHEET 2 OF 5
DATE	06.05.23	TITLE	SCALE 1:1



Dart Aerospace Ltd.

Date: Friday, 15/06/2007 2:48:01 PM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 31794A	Customer	: Dart Helicopters Services
Estimate Number	: 10375	DWG Name	: STEP SPACER
Purchase Order #	:	Part Number	: D30651
Complete Date	: 11/06/2007 8:50:10	DWG Number	: D3065 REV. B

DUEDATE	ORDERED	DELIVERED	
15/05/2007	60	60	

1.0 M2024T3S040-2024-T3 .040 sheet	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE			
07/05/2007	MURD02: Murdoch, Matthew	M2024T3S040	Qty: 7.799	COST: \$34.01	Lot # 03321 Qty. 8

Subtotal:	QTD: 0 CTD: 8	COST: \$34.01					
2.0 WATER JET Internal Operation							
DATE	EMPLOYEE	TYPE	Qty				
07/05/2007	MURD02: Murdoch, Matthew	Run	60.000	Time(hrs) 2.28	COST \$35.45	MTIME(hrs) 2.29	Mach. Cost 47.01
07/05/2007	DROU02: Drouin, Steven	Run	60.000	0.89	\$13.84	0.89	18.27
07/05/2007	DROU02: Drouin, Steven	Run	60.000	0.19	\$2.95	0.19	3.89

Subtotal:	QTD: 180 CTD: 0	3.36	\$121.41	
5.0 SMALL FAB 1 Internal Operation				
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)
07/05/2007	FAUT01: Fauteux, Melanie	Run	60.000	0.20
Subtotal:	QTD: 60 CTD: 0	0.20	\$7.22	

6.0 BRAKE NC Internal Operation				
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)
09/05/2007	BOUC01: Boucher, Sylvie	Run	0.000	3.26
14/05/2007	BOUC01: Boucher, Sylvie	Run	60.000	4.40

Subtotal:	QTD: 60 CTD: 0	7.66	\$276.33	
8.0 HAND FINISHING1 Internal Operation				
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)
08/06/2007	LAUG01: Laughren, Gary	Run	0.000	0.00
08/06/2007	LAUG01: Laughren, Gary	Run	60.000	0.63

Subtotal:	QTD: 60 CTD: 0	0.63	\$24.84	
		TIME	COST	
	Machine Time:	11.86	\$246.89	
	Labor:	11.85	\$182.91	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$34.01	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$463.81	

		COST PER UNIT: \$7.73
<i>AU. 9.75</i>		



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VFNU à / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2007/08/14	0371486

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE P.O.NO.	VIA SHIP VIA
DART GFI-0299	J0165071	PO00004149	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
250	D30651	STEP SPACER C OF C REQ'D <i>E Pasch 8/16</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO **J0165071** SHIPPING MEMO **0371486**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	250 PCS	PO00004149	D30651	B	STEP SPACER	B

MATERIAL	SUPPLIED BY	MAT. REL. NO.
AL 2024-T3 (QQ-A-250/4)	SAMUEL / KAISER ALUMINUM	H/N # 395420A3

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **14 AUGUST 2007**

G.F.I. Q.C. REP. *Carlton Henkel*

570-07



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 17 JUILLET 2007

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 71991 **# de commande SSMQ:** 870053
Customer's order #: **SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
3	5	.040" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	395420A3

Bien à vous,
Yours truly,

Commis à l'administration.
 Administration Clerk.

SHIP TO:
 SAMUEL MISSISSAUGA
 2360 DIXIE ROAD
 MISSISSAUGA, ON, CA L4Y1Z7

SOLD TO:
 SAMUEL LAVAL
 2225 FRANCIS HUGHES
 LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4089691

BL 100910

CUSTOMER PO NUMBER:		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID:	GOV'T CONTRACT NUMBER:
N19210						100910/6	
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	PRODUCT DESCRIPTION:	
1047772	5	20-FEB-2007	2024	BARE	T3	MILL FINISH_COIL	
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	GAUGE:	WIDTH:	LENGTH:		
2752 LB	1 PCS EST.	2011769	0.0400 IN	48.000 IN	0.000 IN		

Certified Specifications

AMS 4037/RevN
 CMMP 019/RevD

AMS-QQ-A-250/4/RevA
 CMMP 025/RevQ

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 395420A3 Cast 364 Drop 30 Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.2 : 68.6 (470 : 473)	46.9 : 47.1 (323 : 325)	17.5 : 17.6

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.20	4.49	0.53	1.28	0.01	0.22	0.02	0.01	0.00	TOT 0.06

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR